

Date: Friday, 19/09/2008 7:15:41 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D412-630-032
 Job Number : 42126
 Estimate Number : 10804
 P.O. Number :
 This Issue : 19/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412630032
 First Issue : / / Type : SMALL / MED FAB Drawing Number : R08-080
 Previous Run : 00015 Project Number :
 Material :
 Due Date : 25/09/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D412630032 Pilot/Co-Pilot Step, RH (Folding)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pilot/Co-Pilot Step, RH (Folding)
 Original B38769 @ CHG001

2.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New paper work and labels are required with the new batch #, @ CHG001
 Re-identify and re-package.

Return to stock

Location: B

4.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D412-630-032	CHG	CHG001
DESC.	Folding Step, RH	STC	SH96-69
LOT	B38769	STC	SR00598NY
MODEL	Bell 205/212/214/412	STC	SR00595/7NY
MADE IN CANADA		D2729-1	

Date: Wednesday, 23/04/2008 10:22:23 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 38769
 Estimate Number : 10824
 P.O. Number :
 This Issue : 23/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412630032
 Drawing Number : IIN D412-630
 Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : L
 Previous Run : 35820 Material :
 Due Date : 30/04/2008 Qty: 2 Um: Each

Written By :
 Checked & Approved By :
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC
 EST. REV. C 07.11.12 ecn 1019, nochg EC
 verified by: DD

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-024 CHG001

-032

S 08/08/13

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

E 08/07/28 ②

MF 08-08-13

3.0 D3463042 Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3463-042 Step weldment B35862

P 08/1/20

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-043 Strut ass'y 37089

8/4/23

②

56

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 MS24665302 Cotter Pin



(21)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M106263

SP

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

S080813 (42)

17.0 PACKAGING PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0 D34541 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	33730

SP

19.0 D34543 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	35171

SP

20.0 D34545 Bushing



(22)

Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	34842

8/4/24

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

21.0 D34551 Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description
6 D3455-1. / Spacer

Batch 30226 12

50

22.0 D34553 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description
2 D3455-3 / Spacer

Batch 1328172

50

23.0 D3462042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description
1 D3462-042 Bracket ass'y

Batch 35860

50

24.0 AN3104 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description
1 AN310-4 Nut

Batch 1071397

50

25.0 AN3105 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description
2 AN310-5 Nut

Batch 105280

8/4/24

50

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
26.0	AN3C5A	Bolt
Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Qty Part Number Description Batch 3 AN3-C5A Bolt 106574		
27.0	AN44C12	eyebolt
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN44-C12 Eyebolt MT07923 MT07923 / 24/7		
28.0	AN4C15	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN4C15 BOLT 103248		
29.0	AN5C11	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN5C11 BOLT 103248		
30.0	AN5C15	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN5C15 BOLT 10121		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
31.0	AN960C10	WASHER
<div>Comment: Qty.: 7.0000 EACH(s)/Unit Total: 14.0000 EACH(s)</div> <div>Pick:</div> <div><div>Qty. Part Number Description Batch</div><div>7 AN960C10 Washer 106302</div></div>		
32.0	AN960C516	WASHER
<div>Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)</div> <div>Pick:</div> <div><div>Qty. Part Number Description Batch</div><div>1 AN960C516 Washer 10280</div></div>		
33.0	MS210433	Nut
<div>Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)</div> <div>Pick:</div> <div><div>Qty. Part Number Description Batch</div><div>3 MS21043-3 Nut 107288</div></div>		
34.0	MS24665227	COTTER PIN
<div>Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)</div> <div>Pick:</div> <div><div>Qty. Part Number Description Batch</div><div>2 MS24665-227 COTTER PIN 106093</div></div>		
35.0	MS24665229	COTTER PIN
<div>Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)</div> <div>Pick:</div> <div><div>Qty. Part Number Description Batch</div><div>2 MS24665-229 COTTER PIN 109096</div></div> <div>8/4/23</div>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 38769

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
36.0	NAS1515H5	Washer
<div><div></div><div><div><div>Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)</div><div>Pick:</div><div><div>Qty. Part Number Description Batch</div><div>1 NAS1515H5 Washer 4100133 8/4/23</div></div></div><div><div>M100433</div><div>M106541X</div><div>8/4/23</div><div>8/7/1</div><div>22/08</div><div>50</div></div></div></div>		
37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
<div><div></div><div><div>Comment: INSPECT 100% KITS FOR COMPLETENESS</div><div>8/8/13</div><div>50</div></div></div>		
38.0	PACKAGING 1	PACKAGING RESOURCE #1
<div><div></div><div><div>Comment: PACKAGING RESOURCE #1</div><div>Identify and pack for shipping as per PPP D412-630-031</div><div>Location: <u>B</u></div><div>PPP Rev: <u>32</u></div><div>8/8/13</div><div>50</div></div></div>		
39.0	QC21	FINAL INSPECTION/W/O RELEASE
<div><div></div><div><div>Comment: FINAL INSPECTION/W/O RELEASE</div><div>8/8/14</div><div>50</div></div></div>		
<div><div>Job Completion</div><div></div><div>8/8/14</div></div>		